

Date: Monday, 3/6/2006 1:45:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW INSTALLATION
Job Number : 26051	
Estimate Number : 10044	
P.O. Number : N/A	Part Number : D044662011
This Issue : 3/6/2006 S.O. No. : N/A	Drawing Number : D3075 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : A2
Previous Run : 10001	Material : N/A
Written By : <u>SKG COMMENT Below</u>	Due Date : 3/20/2006
Checked & Approved By : <u>DA 06.03.06</u>	Qty: 20 Um: 10 Each
Comment : Est Rev: C 04.02.19 Added tolerance and ref to DSK086-12 to Step 3 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	26051A	R44 BEARPAW
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Comment: Sub-Component R44 BEARPAW

2.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD044-662-011 CHG002

3.0	D2182B	Neoprene Cushion-.750 bl
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Comment: Qty.: 0.9400 f(s)/Unit Total : 9.4000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 D2182B028 Rubber Cushion B24870

1 Paperwork package

B24870 x 10 = 9.40 SF.

4.0	D2274	Radius Block
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2274 Radius Block B26078B26078 x 10 = 80 B26500 x 9 = 72

5.0	D2529	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 D2529 Washer B26485B26485 x 10 = 8026/06/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:45:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 26051

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2882

Clamp



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

2 D3075-1 Bearpaw(REF)

4 D2882 Clamp

B26051A

~~A24505~~

B20702A

B26051A x 10 = 20 ✓

B24505 x 9 = 36 ✓

B20702A x 1 = 1 ✓

7.0

AN414A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-14A Bolt

M15072 38mcw

M100188 2mcw

④ M100188 x 10 = 40 ✓

8.0

AN415A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

4 AN4-15A Bolt

M19085 38mcw

~~M100188 2mcw~~

④ M19085 x 10 = 40 ✓

9.0

AN960JD416

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 AN960JD416 Washer

M100575

⑤ M100575 x 10 = 80 ✓

10.0

MS21042L4

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

8 MS21042L4 Nut (or -4)

M19085

⑧ M19085 x 10 = 80 ✓

6/6/20
16/6/20
⑩

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/6/2006 1:45:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARPAW INSTALLATION

Job Number: 26051

Part Number: D044662011

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



06/06/21 (10)

Comment: INSPECT 100% KITS FOR COMPLETENESS

06/20/06 (10)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D044-662-011

Location:

Rev. B

AB 06/06/21

(10)

REVB

06/06/20 (10)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/22 (20)

Job Completion



U 06.06.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector







Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

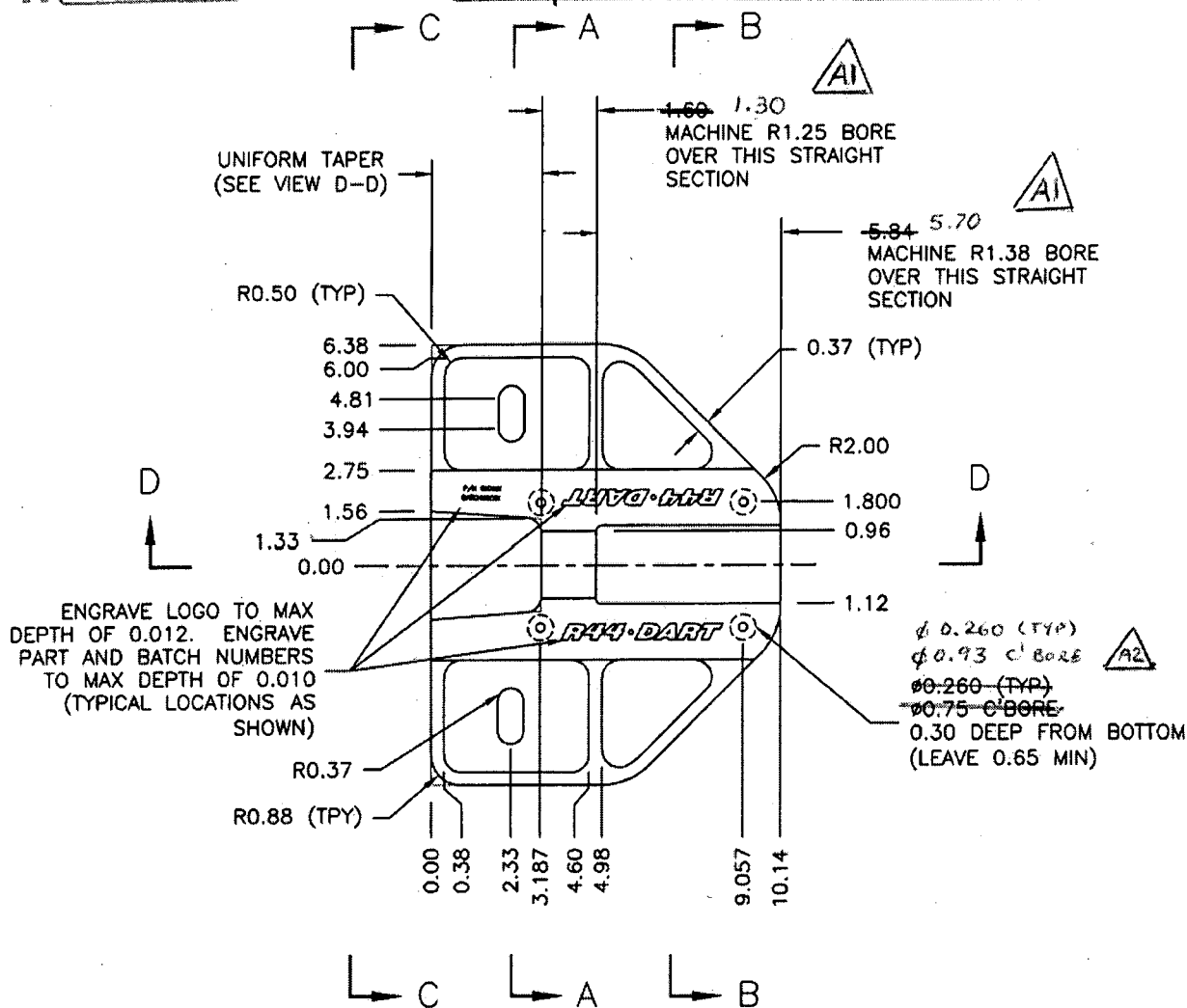
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN 		DRAWN BY 		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 		APPROVED 		DRAWING NO. D3075 REV. A SHEET 1 OF 2	
DATE 02.01.04		TITLE R44 BEARPAW		SCALE 1:5	
A	02.01.04		NEW ISSUE		
A1	 RF 02.02.01		1.30 WAS 1.60 ; 5.70 WAS 5.84		
A2	 RF 03.01.06		ø 0.93 WAS ø 0.75		

RELEASED
02.01.10



D3075-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

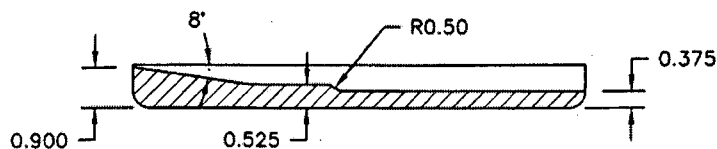
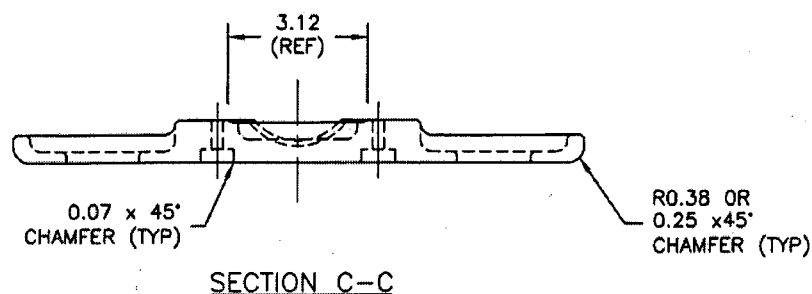
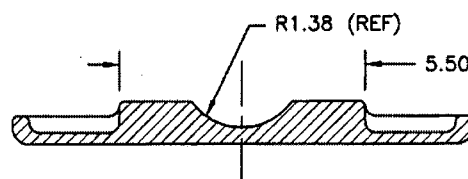
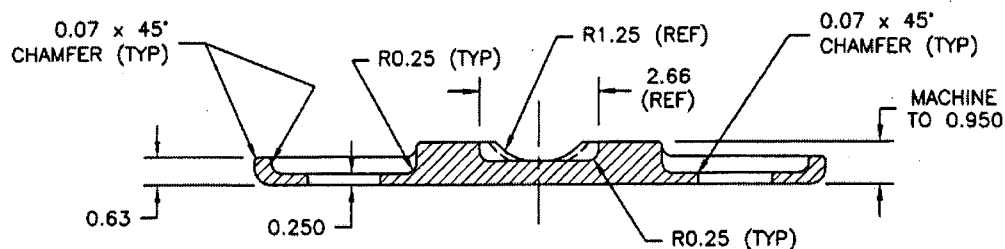
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DART

DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3075	REV. A SHEET 2 OF 2
DATE 02.01.04		TITLE R44 BEARPAW	SCALE 1:4

RELEASED
02.01.10

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